

ASAP Step 05/06 - 06/06 Dart Aerospace Ltd.

Date: Wednesday, 04/06/2008 2:23:49 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 39701		Part Number	: D32075		
Estimate Number	: 11144		Drawing Number	: D3207 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 04/06/2008 S.O. No. :		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : MACHINED PARTS		Due Date	: 05/06/2008 Qty: 4 Um: Each		
Previous Run	: 34217					
Written By	: <u>L</u>					
Checked & Approved By	: <u>L</u>					
Comment	: Est A 04.06.09 New issue KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S125	6061-T6 .125 Sheet	
		Comment: Qty.: 0.0773 sf(s)/Unit Total: 0.3091 sf(s) 6061-T6 .125 Sheet Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) Identify for D3207-5 Batch: <u>105646</u> <u>RB 8-6-5</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3207 Dwg Rev: <u>A</u> <u>RB 8-6-5</u> Prog Rev: <u>A</u>	<u>(S)</u>
		2-Deburr if necessary	<u>81 08/06/05</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>RB 8-6-5</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>(S)</u> <u>08/06/05</u> <u>(X5)</u>
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Form as per Dwg D3207	<u>RB 08/06/05</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/06/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 04/06/2008 2:23:49 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39701

Part Number: D32075

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 0866605 x5

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(5)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

21/F 08/06/05

8.0 POWDER COATING

POWDER COATING



m/05642

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

7:25

OVEN TEMPERATURE:

320°

FINISH TIME:

7:55

F 08/06/05

(5)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



5x

Comment: INSPECT CHEMICAL CONVERSION COAT

M-A

08/06/06

(5)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



5x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8/6/06

SP

11.0 QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

Done 08/06/06

Job Completion



MF 08-06-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

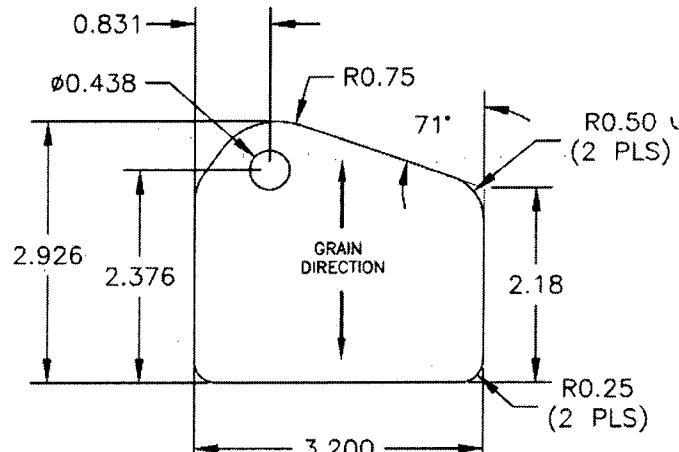
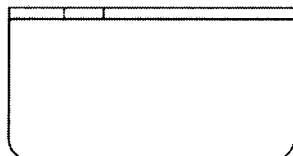
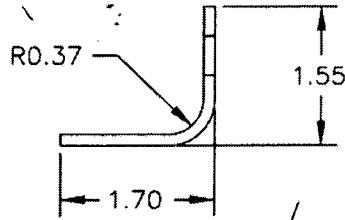
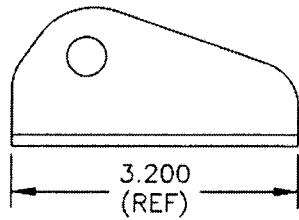
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3207	SHEET 3 OF 3

DATE
04.01.27TITLE
BRACKETSCALE
1:2**RELEASED**
04.04.05**D3207-5 FLAT PATTERN**

W/0 39701

D3207-5 BEND DETAIL**D3207-5 BRACKET**

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39701
Description: BRACKET	Part Number:	D3207-5
Inspection Dwg: D3207 - Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>PS</u>	Audited by: <u> </u>	Prototype Approval: <u> / </u>
Date: <u>8-6-05</u>	Date: <u>08/06/05</u>	Date: <u> / </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

